

Work Order ID 85345

85345

Page 1

Wednesday, June 06, 2012 3:46:23 PM

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, 350
 Start Date: 6/6/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/20/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-06-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 1118161 0.00
 Large Fab

100
 Large Fab

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

(1x)

12-06-13

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
 QC

Quality Control

Memo 0.00

1x 12-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

8/7/04/13

1x 12-06-13

1 7/6 12-6-14

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
-----	---	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 9:30OVEN TEMPERATURE: 400°FFINISH TIME: 10:20

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

M121134

IX ~~Ø~~ mf
12/06/14

1 Ø 12-6-14

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Start Date: 6/6/2012 Start Qty: 1.00

1

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Required Date: 6/20/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Assemble as per dwg

0.00

150

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

1 of BL 12-6-14

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

Envelope

170

Identify as per dwg & Stock Location: D4030-0410

0.00

170

Packaging

Memo

0.00

Packaging

85344

1 of BL 12-6-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

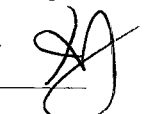
180

QC

Memo

0.00

Quality Control

12/6/18 
MLJ 12/06/15

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 85345

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/6/2012

Required Date: 6/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	53.0000	2	2		SL 12.06.07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		10							
				82506		2							
				83230		8							
				WA005		43							
				70766		2							
				81253		1							
				82897		40							
✓ D3913-1 Rib		Manufactured	No			100	Each	4.0000	1	1		SL 12.06.07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		4							
				74145		0							
				80790		1							
				82918		3							
✓ D3913-15 Wide Handle Plate		Manufactured	No			100	Each	8.0000	1	1		SL 12.06.07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA005		8							
				82919		8							

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Work Order ID: 85345

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/6/2012

Required Date: 6/20/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-3 Rib Manufactured No 100 Each 8.0000 1 1 SS 12.06.07

Location	Loc Qty	Loc Code
WA	7	
69160	0	
74144	0	
82920	3	
84657	4	
WA006	1	
69160	1	

✗ D3913-7 Rib Manufactured No 100 Each 5.0000 2 2 SS 12.06.07

Location	Loc Qty	Loc Code
WA	5	
83908	5	

✓ D3913-9 Hinge Rib Manufactured No 100 Each 12.0000 1 1 SS 12.06.07

Location	Loc Qty	Loc Code
WA	11	
84814	5	
85292	6	
WA006	1	
70138	1	

✓ D3916-041 Rib Assembly Manufactured No 100 Each 6.0000 2 2 B85329 → SS 12.06.07

Location	Loc Qty	Loc Code
WA	4	
84382	4	
WA006	2	
81444	2	

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Work Order ID: 85345

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/6/2012

Required Date: 6/20/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3916-5 Light Rib Manufactured No 100 Each 21.0000 3 3 12.06.07

Location	Loc Qty	Loc Code
WA	21	
77142	1	
82933	10	
82934	10	

✓ D4016-1 Hinge Half, Base Manufactured No 100 Each 22.0000 3 3 12.06.07

Location	Loc Qty	Loc Code
WA	22	
66418	0	
84049	4	
84867	18	

✓ D4017-7 Rib Manufactured No 100 Each 9.0000 1 1 12.06.07

Location	Loc Qty	Loc Code
WA	8	
82969	8	
WA005	1	
69730	1	

✓ D4017-9 Rib Manufactured No 100 Each 17.0000 2 2 12.06.07

Location	Loc Qty	Loc Code
WA	11	
81445	5	
82970	6	
WA006	6	
70341	2	
73531	4	

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Page 3

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Work Order ID: 85345

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/6/2012

Required Date: 6/20/2012

Start Qty: 1.00

Required Qty: 1.00



D4020-11

End Mesh, Basket

Manufactured No

100 Each 9.0000

2

2

385 SJ 12.06.13

Location

Loc Qty

Loc Code

WA

-3

81442

2

83799

2

84972

5

WA035

12

2x



D4021-1

Handle Plate

Manufactured No

100 Each 6.0000

3

3

SJ 12.06.07

Location

Loc Qty

Loc Code

WA

6

69518

0

74316

0

74946

0

84050

6

2x



D4034-041

Aft Upper Rib Assembly

Manufactured No

100 Each 1.0000

1

1

881435 → 1x SJ 12.06.07

Location

Loc Qty

Loc Code

WA

1

78328

1



D4034-043

Fwd Upper Rib Assembly

Manufactured No

100 Each 5.0000

1

1

SJ 12.06.07

Location

Loc Qty

Loc Code

WA

4

81174

3

83756

1

WA006

1

81431

1

1x

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Start Date: 6/6/2012

Required Date: 6/20/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F
Expanded Metal Flat SS

Purchased

No

100 sf

634.1584

33

33

Handwritten: 12-06-13

Location

Loc Qty

Loc Code

WA

40.4354

121471

6.7668

121738

33.6686

WA035

593.7229637

117197

102.9036

120917

101.57273

121521

0.00013372

121849

389.2465

AN3-10A

Purchased

No

150 Each

161.0000

6

6

Handwritten: 33.0

Location

Loc Qty

Loc Code

GA

12

119084

12

ST351

149

117795

2

120873

147

AN960JD8

NAS1149DN832J

Purchased

No

150 Each

0.0000

2

2

Handwritten: 11/16/13

Washer

D2931

Manufactured

No

150 Each

414.0000

2

2

Bumper

Location

Loc Qty

Loc Code

ST504

414

46064

414

D4021-5

Manufactured

No

150 Each

12.0000

2

2

Blanking Plate

Location

Loc Qty

Loc Code

ST084

12

85065

12

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Shop Packet Print

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Dart Aerospace Ltd

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Start Date: 6/6/2012

Required Date: 6/20/2012

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

746.0000

2

2

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

613

111636

36

117601

3

118626

316

120308

258

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

2,101.0000

6

6

Nut

Location

Loc Qty

Loc Code

ST300

2101

115835

4

117885

32

119017

929

119075

138

121349

188

121444

810

NAS1149F0332P

Purchased

No

150

Each

636.0000

12

12

WASHER

Location

Loc Qty

Loc Code

ST275

636

117735

13

119225

10

120986

200

121259

200

121584

36

121585

1

121825

173

17317

3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

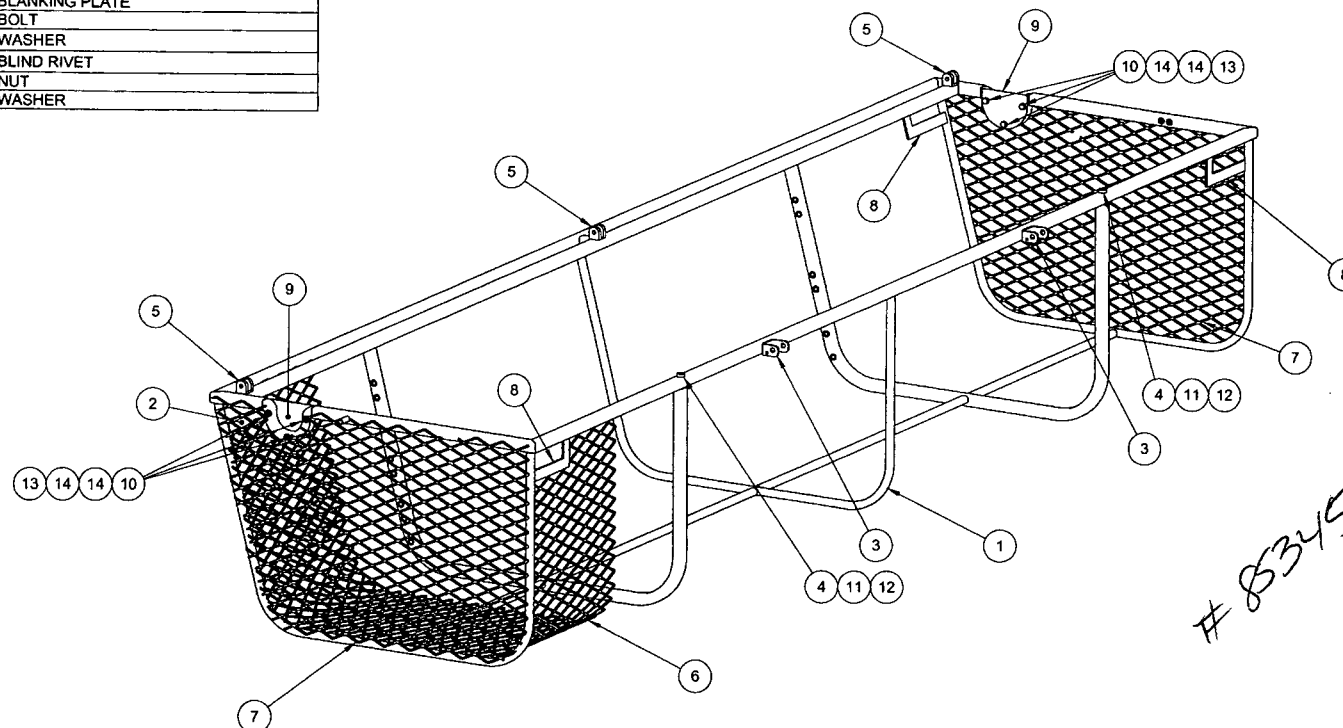
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JFH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3913	REV. A
TITLE LONG BASKET BASE ASSY (350) NTS	SCALE
SHEET 1 OF 6	
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-03-22
JMP

#8345

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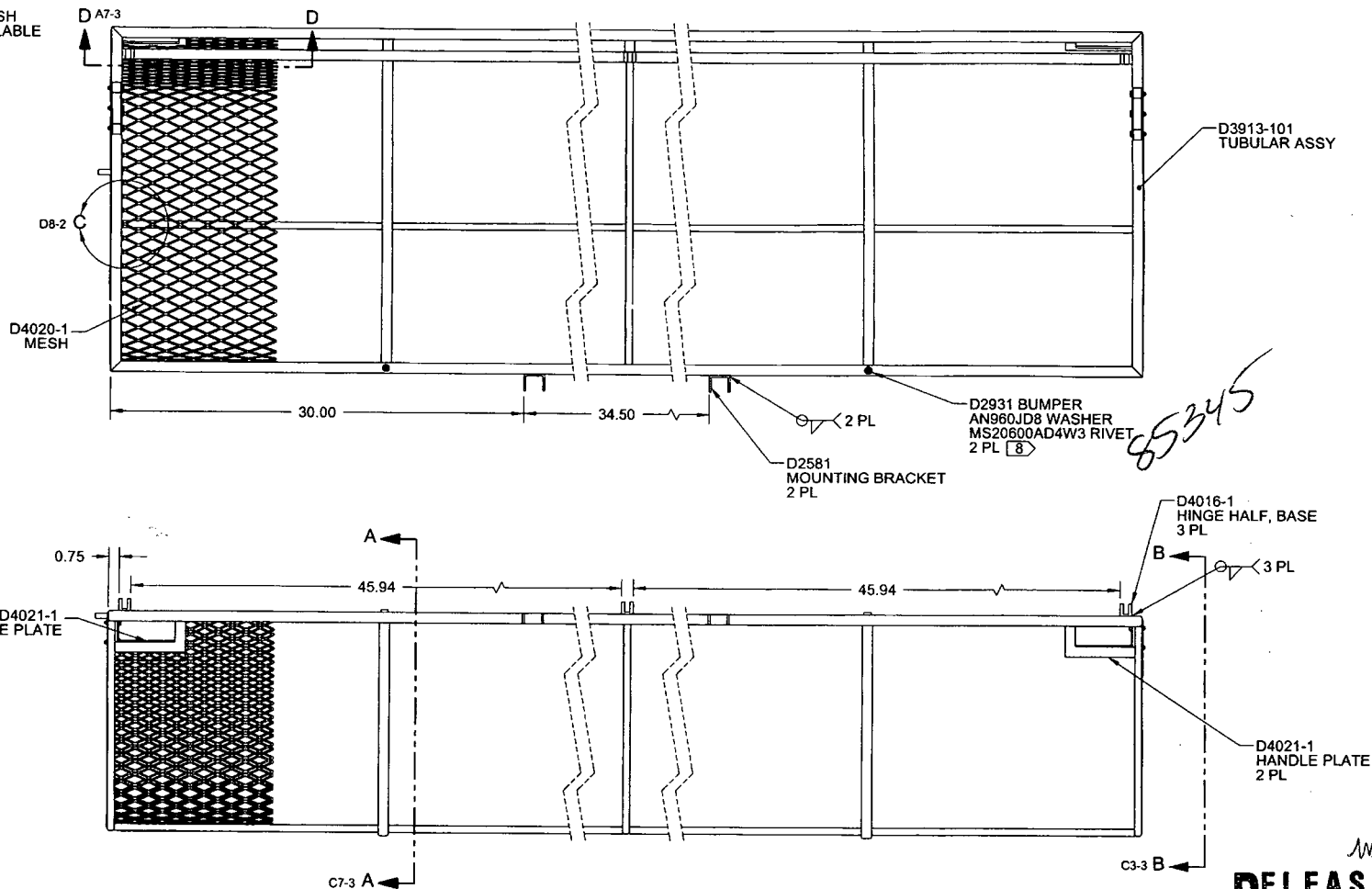
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-17

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JRH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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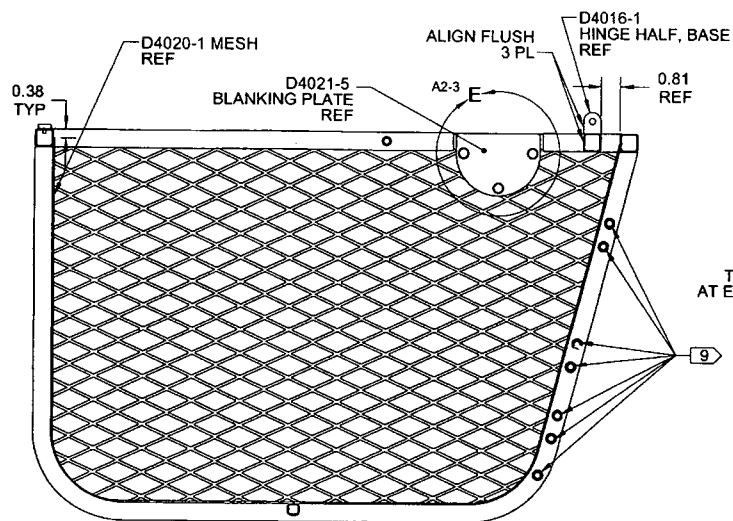
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

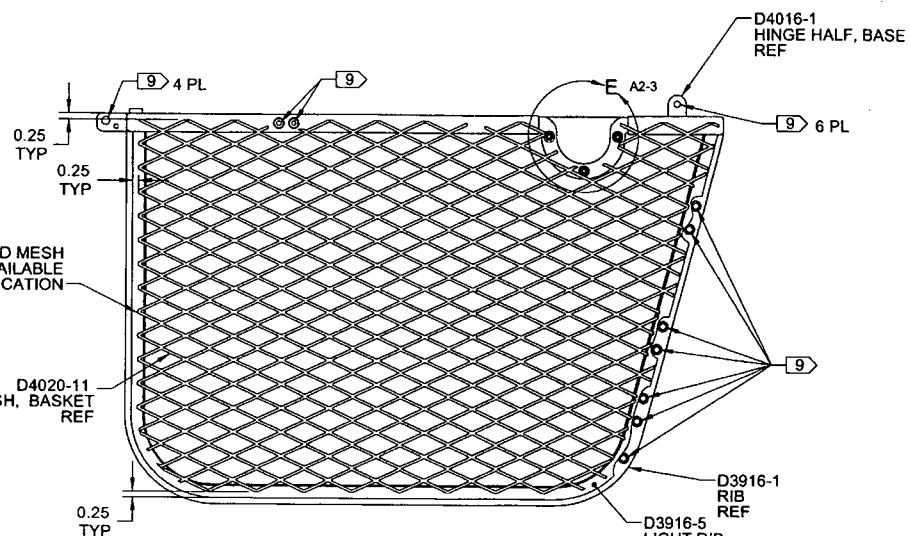
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

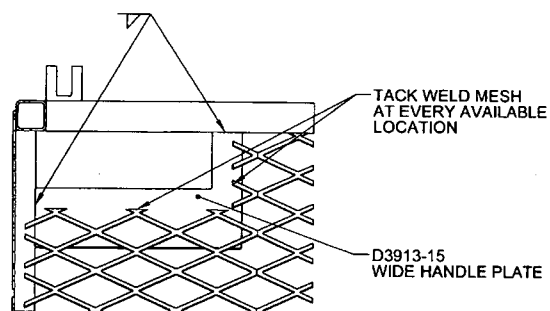
NOTE: Date & initial all entries



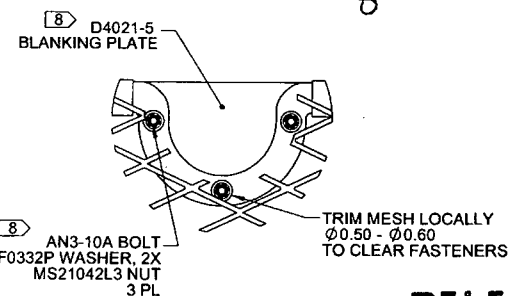
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D
TYPICAL FOR ALL
HANDLE PLATES D7-2



DETAIL E D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	h	D3913	SHEET 3 OF 6
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85345

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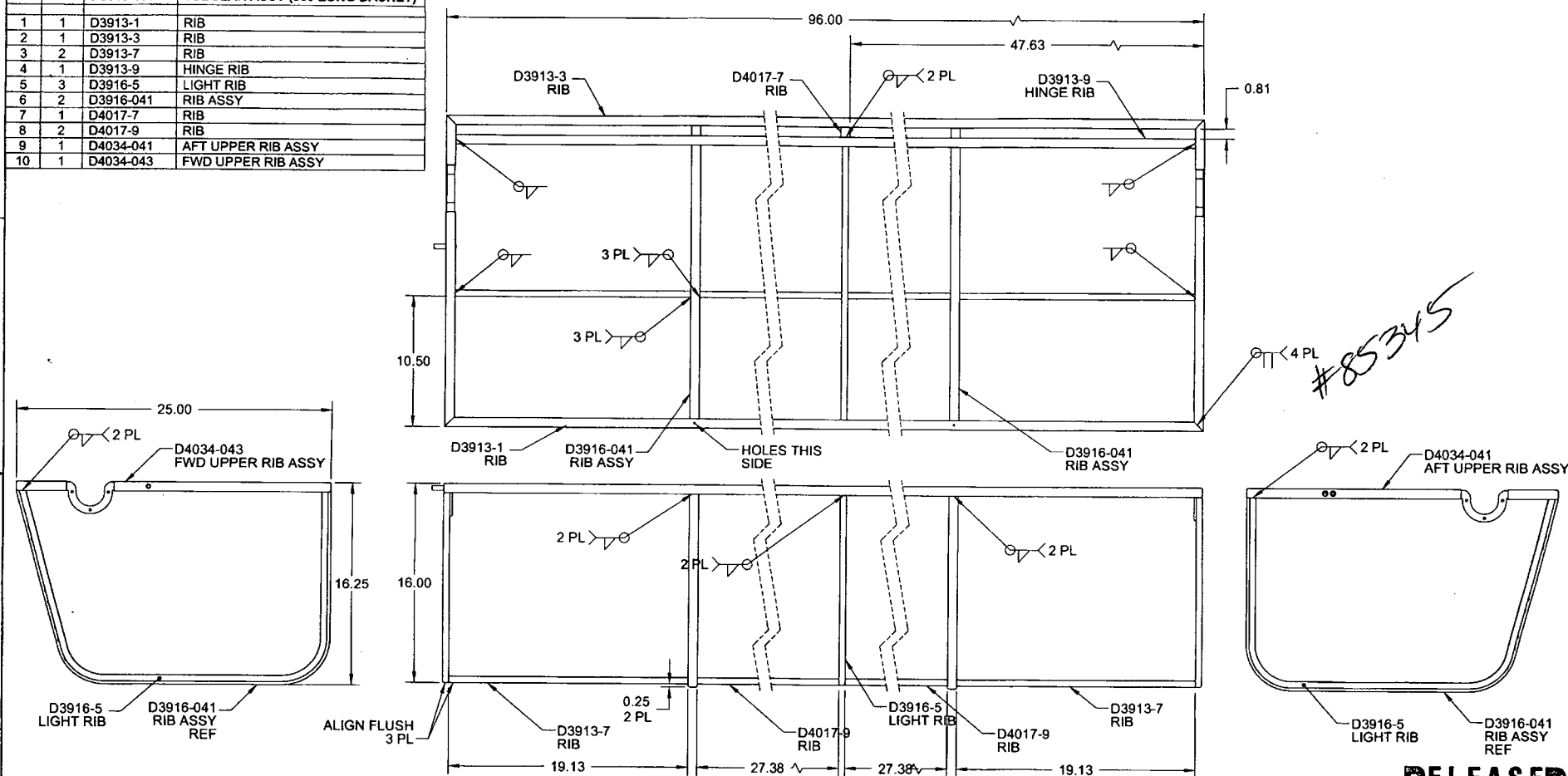
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

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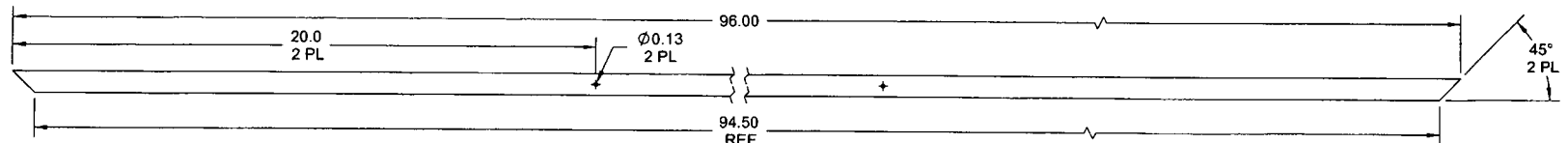
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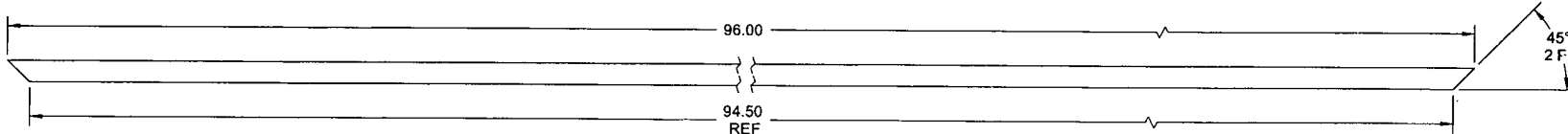
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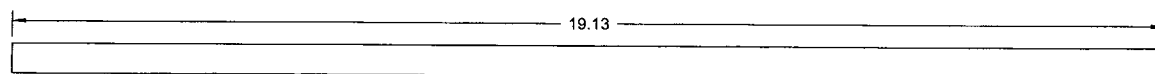
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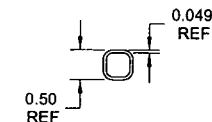
D3913-1 RIB



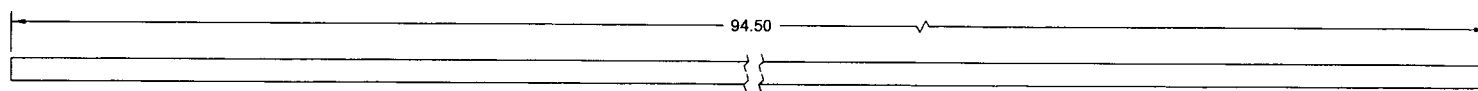
D3913-3 RIB



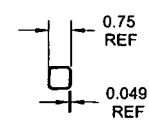
D3913-7 RIB



#85345



D3913-9 HINGE RIB



NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.		D3913	SHEET 5 OF 6
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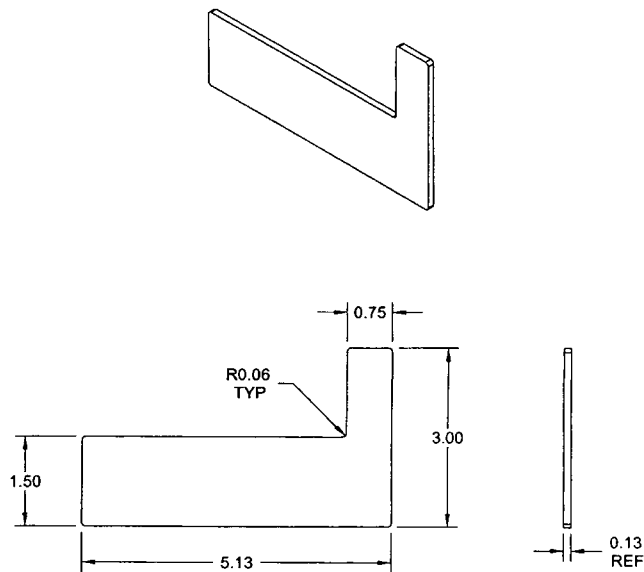
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries